

Work Order ID 92919

November-12-12 3:27:10 PM

92919

Page 1

Item ID: 647.9501

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Quick Release Pin Assembly

Start Date: 12/11/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 03/12/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12-11-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

647.9500

N/C

110

0.00

110

Small Fab

Memo

0.00

Small Fab

1- CUT AND STRIP CABLE AS PER DWG

2- REMOVE SNAP RING ON QUICK PIN BEFORE ASSEMBLING.

3- ASSEMBLE SLEEVE, PIN AND GROUND PLATE AS PER DWG

30x

[Signature] 12/13/12

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

[Stamp]
21
12.4.26

30
can

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube		General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other			

Work Order ID 92919

November-12-12 3:27:11 PM

92919

Page 2

Item ID: 647.9501

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Quick Release Pin Assembly

Stop *NS2*

Start Date: 12/11/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 03/12/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

57541

0.00

Packaging

12/3/12 (30)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/5/12

ME

134-29

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Picklist Print

November-12-12 3:27:14 PM

Page 1

Work Order ID: 92919

92919

Parent Item: 647.9501

647 9501

Parent Item Name: Quick Release Pin Assembly

Start Date: 12/11/2012

Required Date: 03/12/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A 12.12.23 NEW ISSUE DD VERF:jl

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

601.3202		Purchased	No				Each	0.0000		30			
----------	--	-----------	----	--	--	--	------	--------	--	----	--	--	--

601 3202

Quick Release Pin

CBL-1240

CBL-1240

Cable

B92916 (30)**

EPB 13/04/25
22.5
EPB 13/04/25

Location

Loc Qty

Loc Code

GA

984.445189

113565

3.911789

119690

13.0334

122190

467.5

123283

500

22.5

CBL-460

CBL-460

Loop Sleeve

Purchased

No

Each

377.0000

60

**

EPB 13/04/25

Location

Loc Qty

Loc Code

GA

377

123283

200

123389

177

M124336 (60)

647.9511

647 9511

Ground Plate

Manufactured

No

Each

0.0000

30

**

B92908 (30)**

EPB 13/04/25

NCR: Yes / No

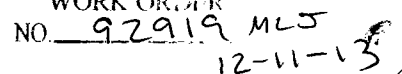
WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

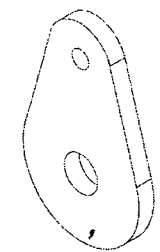
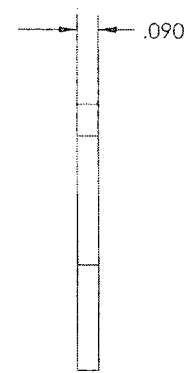
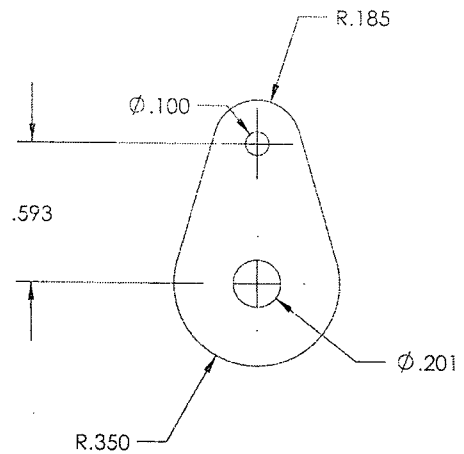
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3. SWAGE USING NICOPRESS NO.1-SC HAND SWAGER. SWAGE UNTIL JAWS ARE COMPLETELY CLOSED.



2	4	601.1054	SWAGING SLEEVE		3
75	3	601.1581	CABLE		
1	2	647.9511	GROUND PLATE	2	
1	1	601.3202	QUICK RELEASE PIN		1
		647.9501	QUICK RELEASE PIN ASSY		
9501	FIND #	PART #	DESCRIPTION	MATL	SPEC.
QTY			PARTS LIST		
NEXT ASSY (S)			ORIGINAL DATE: 06-21-10 DRAWING BY: J. MICHELE P. BRANDO P. BRANDO P. BRANDO CONTRACT # NO.		
647.8900			APICAL INDUSTRIES 2808 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5300		
647.9400					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACES DECIMALS ±.03 3 PLACES DECIMALS ±.010 ANGLES ±.5°			QUICK RELEASE PIN ASSY		
			328 B	SAGE CODE 07/M/66	DWG. NO. 647.9500
			SCALE: NONE		
			1 SHEET 1 OF 2		

92919



647.9511

ORIGINAL DATE 1/20/04-751 06-21-10		APICAL INDUSTRIES	
DRAWN BY: CHECKED K. ISORAND P. BEAVO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BEAVO		QUICK RELEASE PIN ASSY	
QUALITY CONTROL			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		R/W B	REV N/C
		CAGE CODE 07M26	DWG NO. 647.9500
		SCALE NONE	SHEET 2 OF 2